

5/43

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	24601
<b>Description:</b> Lug	<b>Part Number:</b>	D3414-3
<b>Dwg:</b> D3414 Rev. A page 3	<b>Qty:</b>	20
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	Hy	05.10.18	20
2	MV	Cut blanks: 2.50" x 0.500" x 2.250" long Material: 304/316 SS Bar (M304B0.500x02.500) Identify for D3414-3	J.L	05.10.20	20
		Batch: 1118529			
3	MV	Machine as per Folio FA569 and Dwg D3414 Identify as D3414-3	J.L	05.10.21	20
		Dwg Rev A Folio Rev AA			
4	QC2	Inspect parts as they come off the CNC machine	SA	05.10.22	20
5	QC8	Second check	BG	05.10.23	20
6	MV	Deburr	SA	05.10.22	20
7	ST	Identify and Stock	U	05/10/27	20
8	AC	Cost / part: 10.85	SAC	05.10.01	20
9	DC	Close W/O 11.18 Inspect Level 21	LD	05/10/28	20

Rev	Date	Change	Revised By	Approved
A	05.09.13	New issue	KJ/JLM	

**RELEASED**  
05.09.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 17 Date: 05/10/28

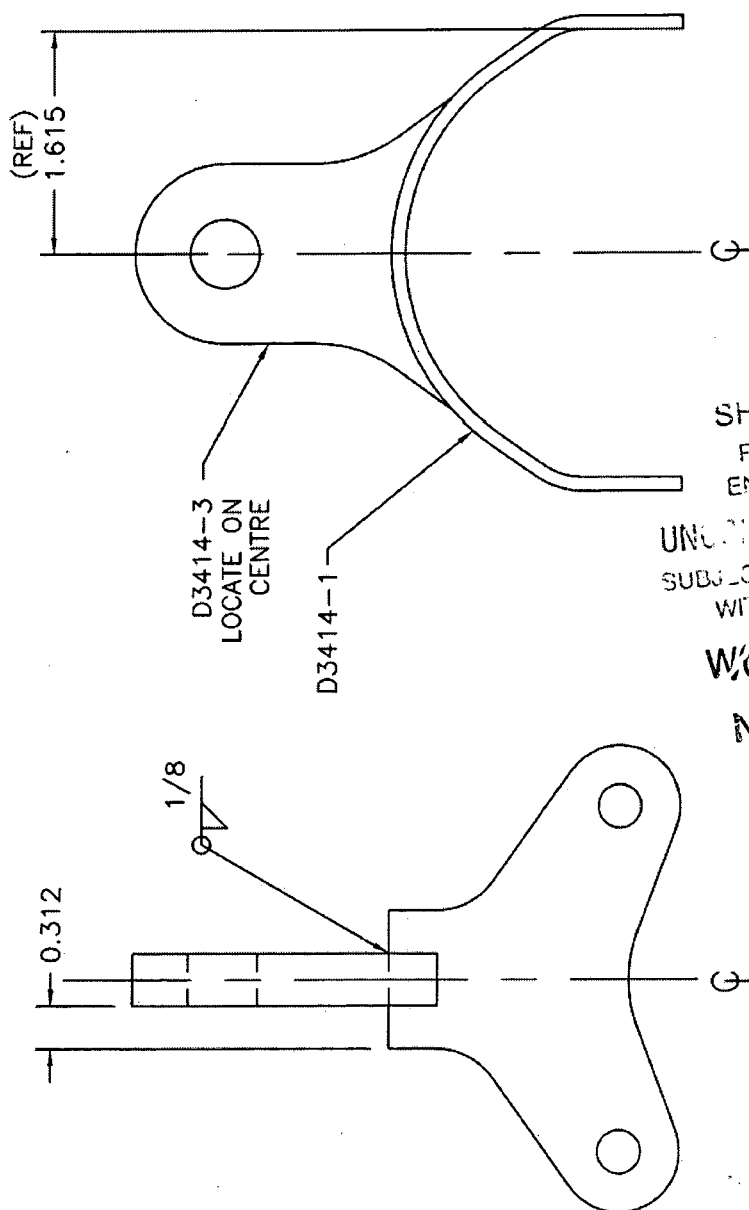
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.	
		PORT HADLOCK, WA			
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. A
				D3414	SHEET 1 OF 3
DATE	05.03.16			TITLE	SCALE
				LUG ASSEMBLY	NTS
A	05.03.16			NEW ISSUE	

RELEASED  
05.09.06 *[Signature]*



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WORK ORDER  
NO. 24601

**D3414-041 LUG ASSEMBLY**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRIC ABOUT CENTERLINE

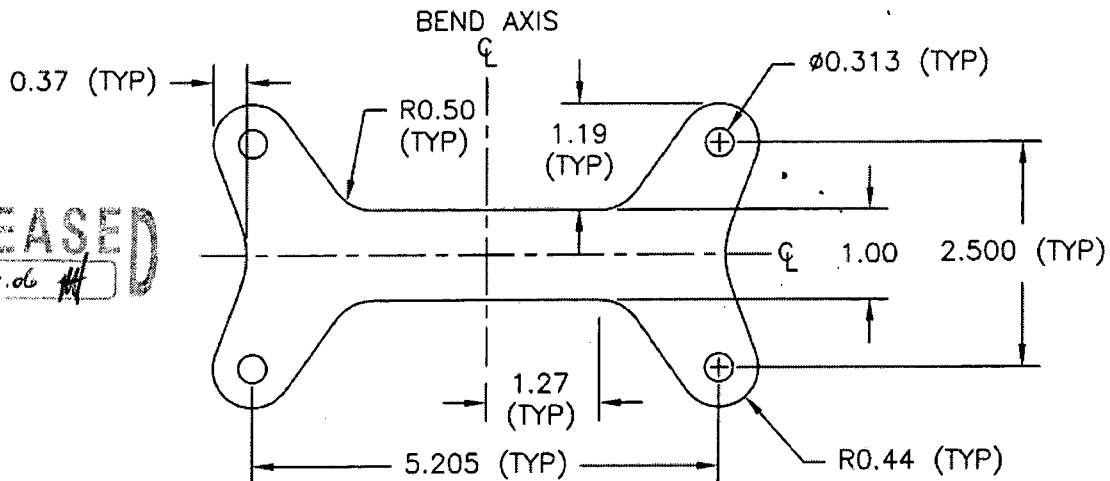
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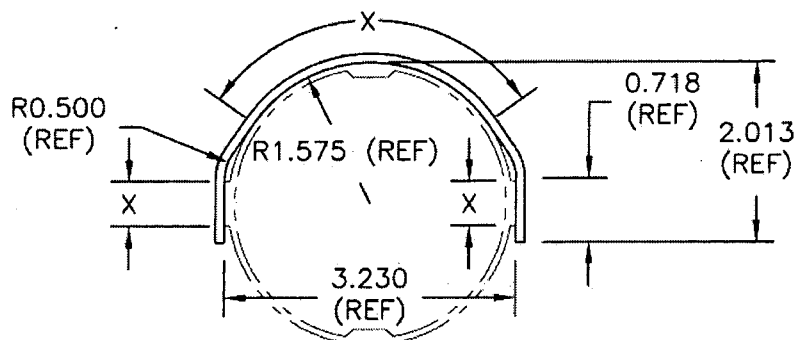
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3414	REV. A SHEET 2 OF 3
DATE 05.03.16	TITLE LUG ASSEMBLY		SCALE 1:2

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**D3414-1 FLAT PATTERN**

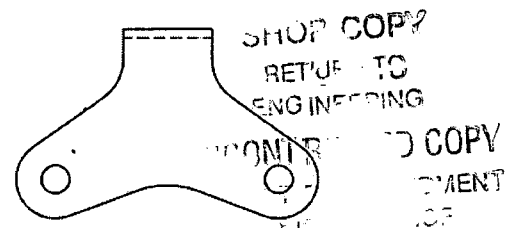
SYMMETRICAL ABOUT BOTH CENTRE-LINES (CL)

**D3414-1 BEND DETAIL**

D3414-1 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

**D3414-1 LUG BRACKET**

- 1) MATERIAL: AISI 304/316 SS SHEET 0.100 THICK (12 GAUGE, REF DART SPEC. M304S12GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES



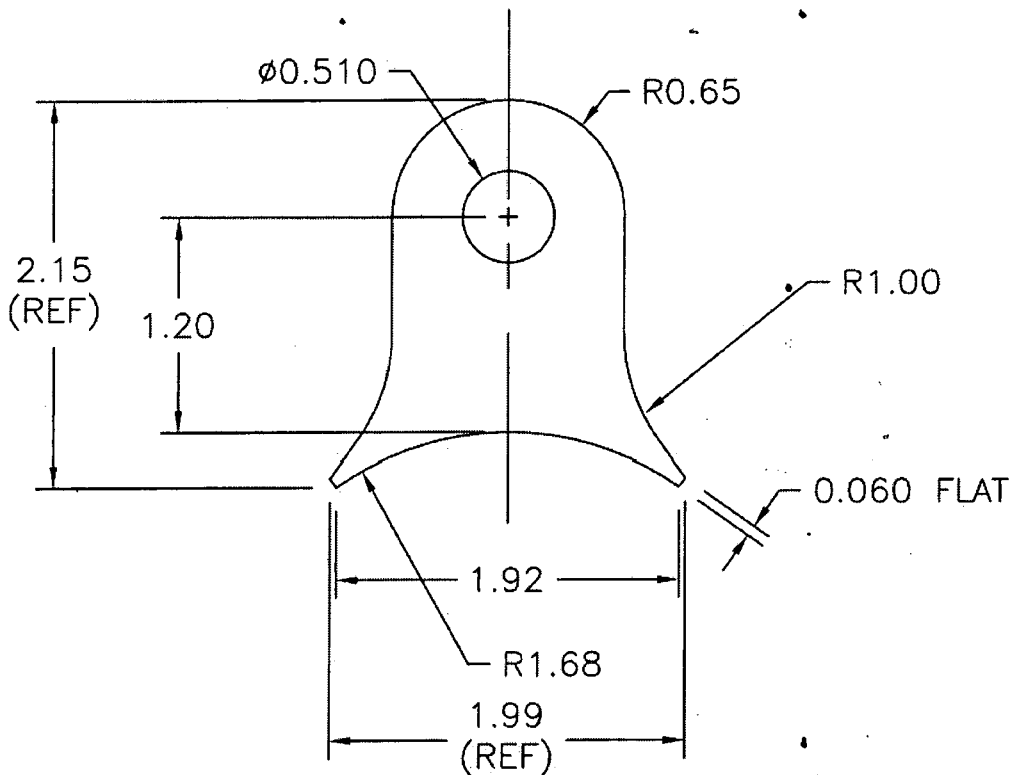
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3414	REV. A SHEET 3 OF 3
DATE 05.03.16		TITLE LUG ASSEMBLY	SCALE 1:1

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05-07-06 [Signature]

**D3414-3 LUG**

- 1) MATERIAL: AISI 304/316 SS PLATE 0.375 THICK (REF DART SPEC. M304S)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Oct 18, 2005  
11:00 am

Work Order No : 0024601  
Project Name : D3414-3  
Project For : WK543  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3414-3  
Description : Lug  
Manufactured : Yes  
Amount Req'd : 20  
Amount Done : 0  
Start Date : 10-18-05  
Est Finish Date : 10-26-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
  
Order Entry No :  
OE Value : 0.00  
  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

